

Work Order ID 95754

95754

Page 1

January-18-13 10:25:05 AM

Item ID: D3063-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 1/16/13

Start Qty: 40.00

40

Cust Item ID:

Required Date: 1/31/13

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>13-01-21</u>	Tooling:	Date:	Run	Start	*NR1*
QC:		Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3063	Rev A								
100 *100* Bandsaw	SHEAR Jeaspa Bandsaw	0.00 Cut blanks 4.000" x 2.500" x 0.625" thick							<u>BT 13-02-27</u>
110 *110* HAAS 1	HAAS CNC VERTICAL MACHINING #1 HAAS CNC vertical machine #1	0.00 Memo 1-Machine per folio FA175 and Dwg D3063 2-Deburr & Tumble	<u>13-03-01</u>	<u>BT 13-03-02</u>	<u>(x 40)</u>				
120 *120* QC	QC2- Inspect parts off machine FAI/FAIB Quality Control	0.00 Memo	<u>13-03-01</u>	<u>40</u>	<u>(x 40)</u>				

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
	Centre Not Concentric to O/S <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
	Cracks <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
	Crushed/Crimped. <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
	Cuffs <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
	Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
	Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
	Ripples in Bend <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>								
	Torque Waves in Extrusion <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
	Turning Sequence <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
	Wave/Twist in Tube <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

Work Order ID 95754***95754***

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Required Date: 1/31/13

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40

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC	QC8- Inspect parts - second check	0.00	B.A	13 03 05		40	0		DAS 08 9-09

Quality Control

140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA003</u>	0.00	40	0	<u>k</u>
	Memo	0.00			13-03-08
	*** STOCK IN STEP CELL***				

150 *150* QC	QC21- Final Inspection - Work Order Release	0.00	13 3 12	<u>BB</u>
Quality Control	Memo	0.00		

MB-03-12

NCR: Yes / No

WORK ORDER NON-COMPLIANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup	RC										
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATECORY											
Landing Gear	General										
	Bending	General			Grain	Ovalized			Pressure/Forced		
	Centre Not Concentric to O/S	Bend	General			Hardware	Over/Under tolerance			Temperature/Cure	
	Cracks	BOM/Route	General			Inspection Incomplete	Part Incorrect			Weld	
	Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear	Part Lost/Missing			Wrong Stock Pulled	
	Cuffs	Burrs	General			Maintenance	Part Moved				
	Heat Treat	Contamination	General			Mislabeled	Positioned Wrong				
	Inspection Strip in Tube	Countersink	General			Misread	Power Loss/Surge				
	Ripples in Bend	Cut Too Short	General			Offset					
	Torque Waves in Extrusion	Drill Holes	General			Out of Calibration					
	Turning Sequence	Drawing	General			Out of Sequence					
	Wave/Twist in Tube	Finish	General			Outside Dimensions					
		Folio	General								
			General								
			General								
			General								
			General								

Picklist Print

January-18-13 10:25:04 AM

Page 1

Work Order ID: 95754

Parent Item: D3063-1

Parent Item Name: Support

Start Date: 1/16/13

Required Date: 1/31/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.10.04Re-format; Blank size changeKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.625X02.500 6061-T6 Bar .625 x 2.50	Purchased	No				100	f	17.1363	0.3417	14.387368			
---	-----------	----	--	--	--	-----	---	---------	--------	-----------	--	--	--

Location	Loc Qty	Loc Code	
MAT049	17.136316		
120603	5.136316 ✓ 14		
123279	12 ✗ 26		
		4.74	
		3.86	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>	
	Centre Not Concentric to O/S	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>	
	Cracks	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>	
	Crushed/Crimped.	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>	
	Cuffs	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>	
	Heat Treat	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>	
	Inspection Strip in Tube	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>	
	Ripples in Bend	<input type="checkbox"/>			Offset	<input type="checkbox"/>			 	<input type="checkbox"/>	
	Torque Waves in Extrusion	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>			 	<input type="checkbox"/>	
	Turning Sequence	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>			 	<input type="checkbox"/>	
	Wave/Twist in Tube	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>			 	<input type="checkbox"/>	
						Pressure/Forced	<input type="checkbox"/>				
						Temperature/Cure	<input type="checkbox"/>				
						Weld	<input type="checkbox"/>				
					Wrong Stock Pulled	<input type="checkbox"/>					
					Other	<input type="checkbox"/>					

DART AEROSPACE LTD	Work Order:	95754
Description: Support	Part Number:	D3063-1
Inspection Dwg: D3063	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>S.S</i>	Audited by:	<i>B.A</i> <i>DAS</i> <i>08</i>	Prototype Approval:	N/A
Date:	13-03-01	Date:	13/03/05 9-99	Date:	N/A

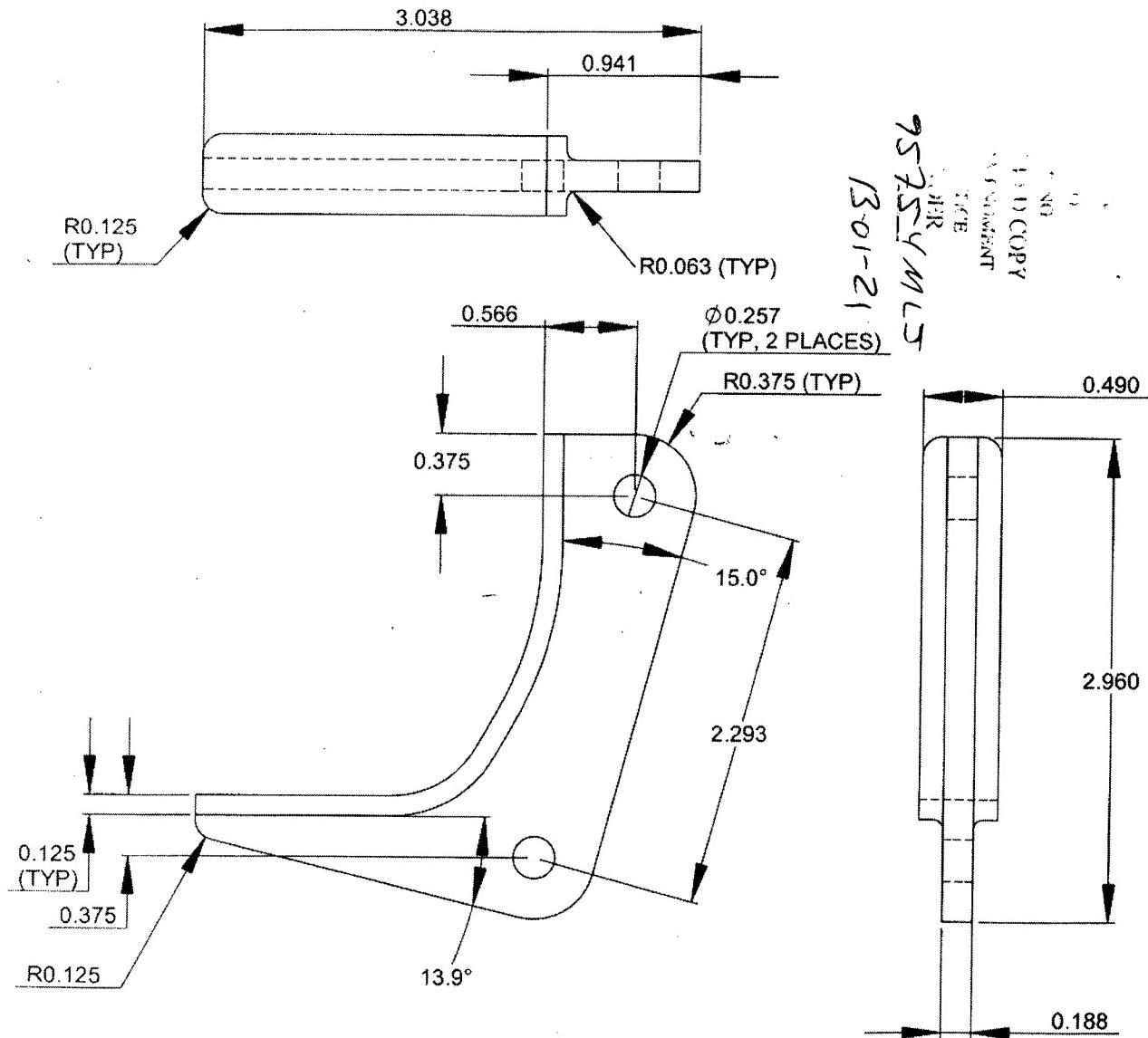
Rev	Date	Change	Revised,by	Approved
A	04.01.21	New Issue	KJ/RF	#

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
DATE	02.09.10	TITLE	SCALE 1:1

RELEASED
02.04.2011

A 02.09.10 NEW ISSUE

**D3063-1 SUPPORT**

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11)
(REF DART SPEC M6061T6B OR M6061T6S)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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